DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027690
Date Inspected: 24-May-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	See Below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG/Tower

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower 13 Meter El. (Observation of welding and QC inspection of the shear plate to diaphragm plate connection), welding of corner stiffener plates and QA/MPT verification.

Will Clifford-Tower Base (Observation of welding and QC inspection of tower base stiffener) and observation of the excavation on the ESW shear plates identified as joints "E" and "M", QA/MPT verification and OBG punch list items.

Matt Daggett-OBG W13 Drop-In Plates (Observation of welding, QC inspection and testing).

Scott Croff-Skyway (Observation of welding and QC inspection of bike path cantilever beams, CCO#233) Pier 7 (Observations of work on the East and West tower heads, RFI-2549R03).

Doug Frey-OBG E13 (Observation of welding, excavations, repair welding, QC inspection and testing of drop-in panel and longitudinal stiffener splices).

Craig Hager-OBG E13 (Observations of welding and QC inspection of the longitudinal stiffeners at the drop-in splices).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Doug Frey, Craig Hager, Scott Croff, William Clifford and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

This QALI continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates). Also, this QALI performed survey and prepared update documentation of the East and West OBG.

Modifications of Cable Bands

This QAI verified the arrival of four (4) cable band assemblies to the job site from various machine shops during this shift. This QAI also verified the amount of material removed from the female cable band half contact surface which appeared to be approximately 15 mm. At the conclusion of this verification this QAI observed ABF personnel chamfering the inside edge of the cable band to a sloping transition of 5 mm: 20 mm utilizing a 9" grinder with a sanding disc attached to achieve a smooth finish. Also observed by this QAI was the preparation of the finishing the new cut surface edge to a 2 mm radius and a 5 mm radius at the suspender rope saddle. The following cable bands were received with the required work completed during this shift: WPP108 and WPP110. Reference Bay Bridge Mets Mail: Cable Band Machining, dated Friday, May 18, 2012.

QA Note: Photographs are on file.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer